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D3913-041
Job Sheet 183324



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/16/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/19/18		0.00	0.00	Start Up Large Fab-5		DC 08-09-25
100	Large Fab	1 pcs	10/19/18		0.00	10.00	Large Fab 1		CPC
110	QC	1 pcs	10/19/18		0.00	0.00	QC9		MS
120	QC	1 pcs	10/19/18		0.00	0.00	QC5		BR 18-10-18
125	HandFinish	1 pcs	10/19/18		0.00	0.29	HandFinish2		BR 18-10-19
130	Powdercoat	1 pcs	10/19/18		0.00	0.93	Powdercoat2		ML 18-10-19
135	Packaging	1 pcs	10/19/18		0.00	0.00	Packaging1		ML 18-10-19
140	QC	1 pcs	10/19/18		0.00	0.00	QC3		ML 18-10-19
150	HandFinish	1 pcs	10/19/18		0.00	0.50	HandFinish4		ML 18-10-19
160	QC	1 pcs	10/19/18		0.00	0.00	QC5		ML 18-10-19
170	Packaging	1 pcs	10/19/18		0.00	0.00	Packaging3-2		OCT 19 2018
180	QC21-SA	1 Ea	10/19/18		0.00	0.00	QC21		21 OCT 19 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M138951 START: 8:15 OUT: 3:15 FINISH: 8:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097503
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5096632
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5093386
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5096630
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5108295
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5104485
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5109089
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5109952
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	510912
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5099924
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5108388 26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5109359
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5108590
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5109408
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5109409
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5098052
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5102780
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5089298
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5076007
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5094592-1
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5103666
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5108637

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	92	0
	D3913-1	1	7	0
	D3913-15	1	22	0
	D3913-3	1	8	0
	D3913-7	2	16	0
	D3913-9	1	12	0
	D3916-041	2	18	0
	D3916-5	3	30	0
	D4016-1	3	10	0
	D4017-7	3	58	0
	D4017-9	2	20	0
	D4020-11	2	35	0
	D4021-1	3	55	0
	D4034-041	1	9	0
	D4034-043	1	9	0
	D4672-1	2	24	0
	M304EX0.75-16F	33	2,179	0
	AN3-10A	6	301	0
	D2931	2	958	0
	D4021-5	2	46	0
150-HandFinish	MS20600-AD4W3	2	357	0
	MS21042L3	6	3,308	0
	NAS1149F0332P	12	3,621	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / DISCREPANCY

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Re Use Suspected Unapp
Part No. _____	
NCR No. _____	

Date :	Step #:
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Description Work Order Deviation

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DART
AEROSPACE

Container No: S113445

Part: D3913-041

Job No: 183324

Serial No/Batch: S113445

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Date: 09/25/10

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QA Coordinator
Approval

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				